

162695

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

100

100

DAS

13

Run Start *NR1*

Stop *NR2*

[illegible]

Work Order ID 162695

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162695

Page 2

Item ID: D2230-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Lug

Start Date: 6/26/2017 Start Qty: 100.00

100

Cust Item ID:

Required Date: 7/6/2017 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo <i>N/A</i>	0.00 1.00		DAS 38 9-89		_____	_____	_____	_____
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo <i>N/A</i>	0.00 1.00		DAS 38 9-89		_____	_____	_____	_____
160 *160* Powdercoat Powder Coating	White Gloss(Ref:43.5.1) per QSI005 4.3-Alum Memo <i>N/A</i> START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.74		DAS 38 9-89		_____	_____	_____	_____

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Page 3

Item ID: D2230-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 6/26/2017 Start Qty: 100.00 ***100*** Cust Item ID:
Required Date: 7/6/2017 Req'd Qty: 100.00 ***100*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 2.00				<u>100</u>			DAS 38 1-89 JUL 03 2017
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>Stor</u> Memo	0.00 1.00				<u>100</u>		JUL 05 2017	DAS 6 2-89
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 10.00						17/7/6	



JUL 06 2017

Picklist Print

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Page 1

Work Order ID: 162695

162695

Parent Item: D2230-1

D2230-1

Parent Item Name: Mounting Lug

Start Date: 6/26/2017

Required Date: 7/6/2017

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D00.11.01 Added inspection level 8, and removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P		Purchased	No			110	Each	0.0000	1	100			
D2230-1P									**				
Lug													
D2423		Manufactured	No			110	f	304.4802	0.0683	7.189474			
D2423									**				
Lug Extrusion													

Location

Metec

115229

127892

148835

Loc Qty

304.4801737

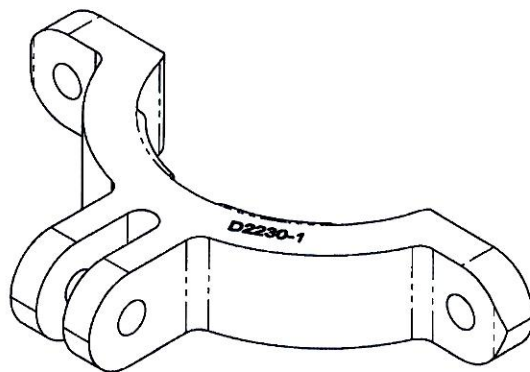
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83.2745647

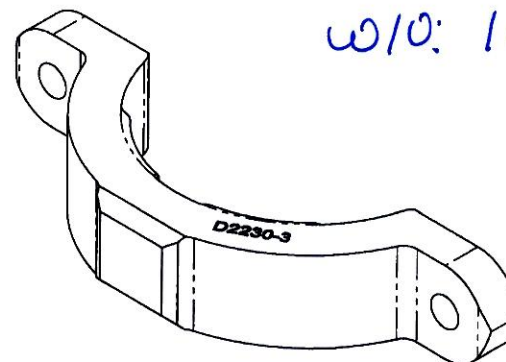
157.205609

Loc Code

100x SPI 7 to 26
JUL 06 2017



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

DAS
13
9-89

JUN 08 2017

W/O: 162695

RELEASED
0162695

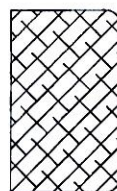
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	98.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



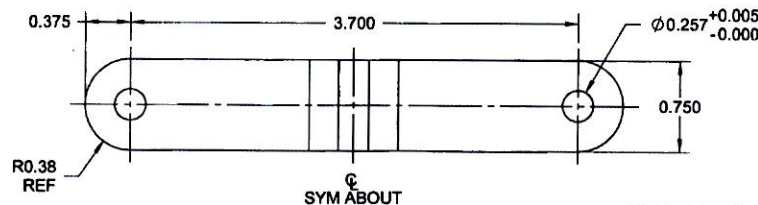
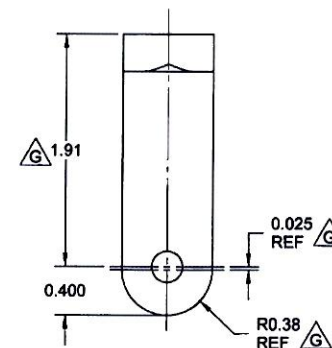
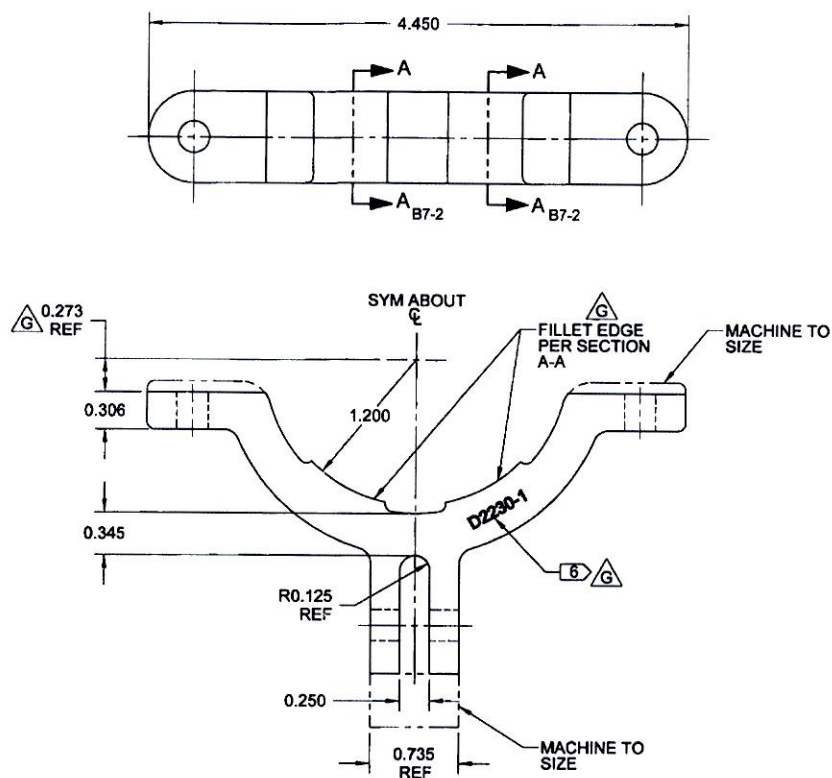
NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

SECTION A-A D4-2
SCALE 2X



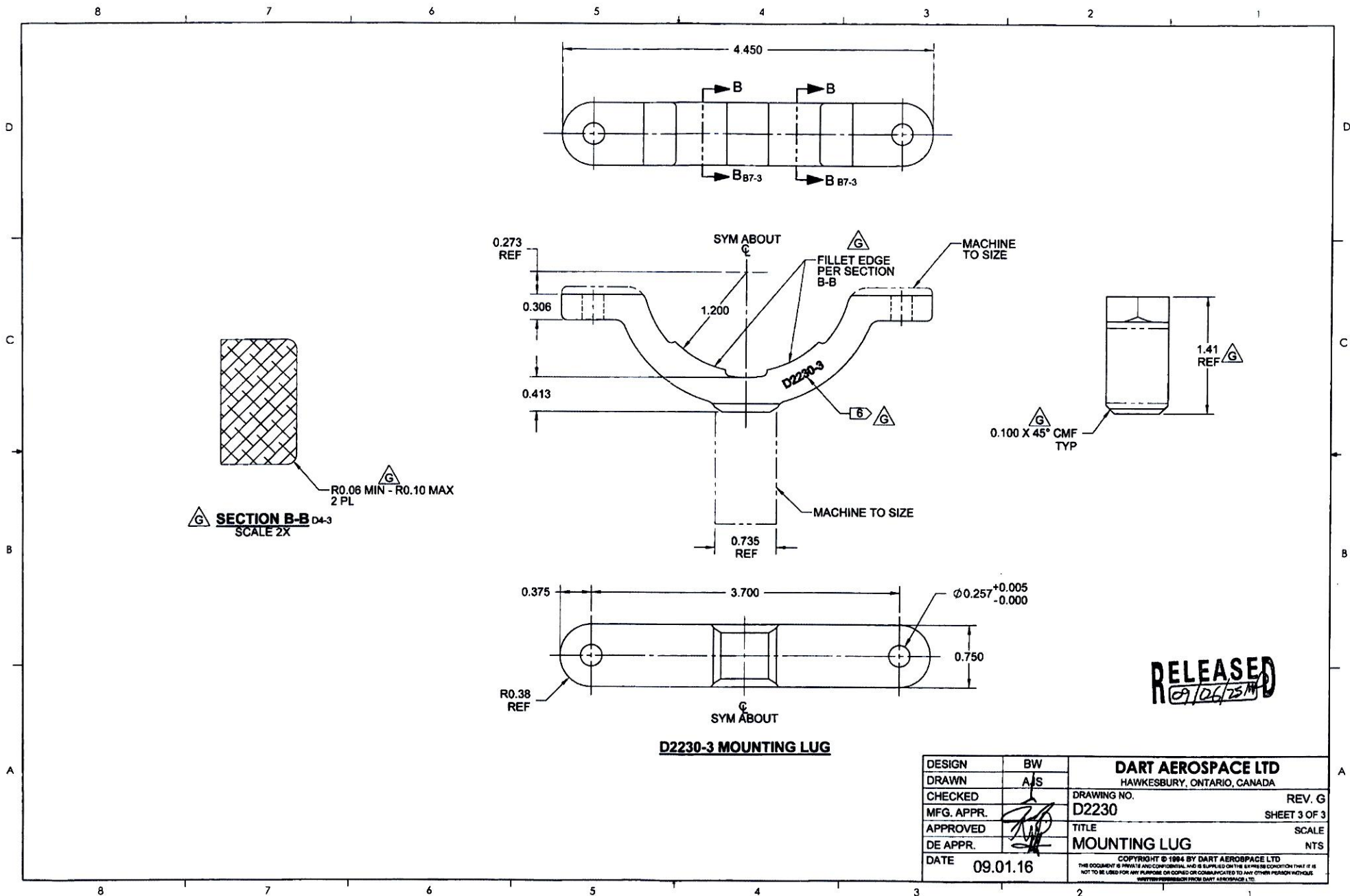
R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

RELEASED
09/06/25/10

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36643

Purchase Order Date 6/9/2017

PO Print Date 6/9/2017

Page Number 1 of 2

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METEL METAL TECHNOLOGY INC.
207 EMMY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUN 12 2017

Contact Name
Vendor Phone 613 678 3957

Ship To Contact
Ship To Phone
Ship Via: Dart Truck
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2230-P AS PER DWG D2230 REV. G B162695 ALODINE AND PAINT AS PER QSI 005	Lug	7/6/2017 Yes 7/6/2017		100.00 Each	\$16.10	\$1,610.00
Line Total:							\$1,610.00
2	D2230-P AS PER DWG D2230 REV. G B162695 ALODINE AND PAINT AS PER QSI 005	Lug	8/7/2017 Yes 8/7/2017		100.00 Each	\$16.10	\$1,610.00
Line Total:							\$1,610.00

Note:

6/9/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21739
Date: Jun 20, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 36043	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jun 20, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug alodined and painted as per QSI005	Each	100	100	
D2230-1 Mounting Lug alodined and painted as per QSI005 Aug 7, 2017	Each	100		100
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.		DAS 38 9-89		
Received by <u>SP176-Hp</u>		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

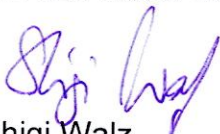
same

Quantity	Part Number	Part Name	Paint Batch #	P.O. Number
100	D2230-1	Mounting Lug	21012	36643

MATERIAL: supplied by DART B148835

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, June 20, 2017